

Date: Friday, 01/08/2008 3:31:52 PM  
 User: Julie Lecocq

## Process Sheet

|                       |  |          |                |                  |                        |     |      |
|-----------------------|--|----------|----------------|------------------|------------------------|-----|------|
| Customer              | : CU-DAR001 Dart Helicopters Services  |          |                | Drawing Name     | : END FITTING ASS'Y LH |     |      |
| Job Number            | : 40960  |          |                | Part Number      | : D3763043             |     |      |
| Estimate Number       | : 13344  |          |                | Drawing Number   | : D3763 REV B          |     |      |
| P.O. Number           | :  |          |                | Project Number   | : N/A                  |     |      |
| This Issue            | 01/08/2008   | S.O. No. | :              | Drawing Revision | : B                    |     |      |
| Prsht Rev.            | : NC   |          |                | Material         | :                      |     |      |
| First Issue           | 1 /  | Type     | LARGE FAB ASSY | Due Date         | : 21/08/2008           |     |      |
| Previous Run          | : 40959  |          |                | Qty:             | 4                      | Um: | Each |
| Written By            | :  |          |                |                  |                        |     |      |
| Checked & Approved By | : <u>JUL 08.8.05</u>   |          |                |                  |                        |     |      |
| Comment               | : Est Rev:A 08-05-20 new issue DD verified by:ec<br>Est Rev:B 08-07-18 revB as per dwg DD verified by:EC |          |                |                  |                        |     |      |

## Additional Product

Job Number:



| Seq. #:   | Machine Or Operation: | Description :                |  |
|---|-----------------------|------------------------------|--|
| 1.0   | PACKAGING 1           | PACKAGING RESOURCE #1        |  |
| <b>Comment:</b> PACKAGING RESOURCE #1<br>Pick Packing Kit   |                       |                              |  |
| 2.0   | D37631                | End Fitting                  |  |
| <b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)<br>End Fitting<br>batch: <u>B40994</u> ✓ SP 08.08.13 (4X)  |                       |                              |  |
| 3.0   | D37635                | Tube                         |  |
| <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)<br>Tube<br>batch: <u>B40705</u> ✓ SP 08.08.13 (4X)   |                       |                              |  |
| 4.0   | LARGE FAB 1           | LARGE FABRICATION RESOURCE 1 |  |
| <b>Comment:</b> LARGE FABRICATION RESOURCE 1<br>1-make a 0.063" chamfer on D3763-1 fitting before ass'y SP 08.08.13<br><br>2-assemble and tack weld as per dwg D3763 using locating pin <del>D3763-1</del> <u>D3763A</u> SP. 08.08.13.<br>*****look at dwg before assembling parts (LH)*****<br>*****remove pin before welding***** |                       |                              |  |
| 3-weld as per dwg D3763 QSI004<br>Alum. rod Batch: <u>M108037</u> SP 08.08.13 (4X).   |                       |                              |  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END FITTING ASS'Y LH

Job Number: 40960

Part Number: D3763043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC9

VISUAL WELDING INSPECTION



01/08/14  
108/08/14

(X4)

Comment: VISUAL WELDING INSPECTION

6.0 QC5

INSPECT WORK TO CURRENT STEP



10808-14 (4)



10808-14 (P10)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: GA

MF 08-08-14

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(4)

10808-15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-14

10808-14

6.1 Chemical conversion cost.  
10808-14

10808-14

(X4)

6.2 QC3 108-08-14

(X4)

W/O: 40960

## WORK ORDER CHANGES

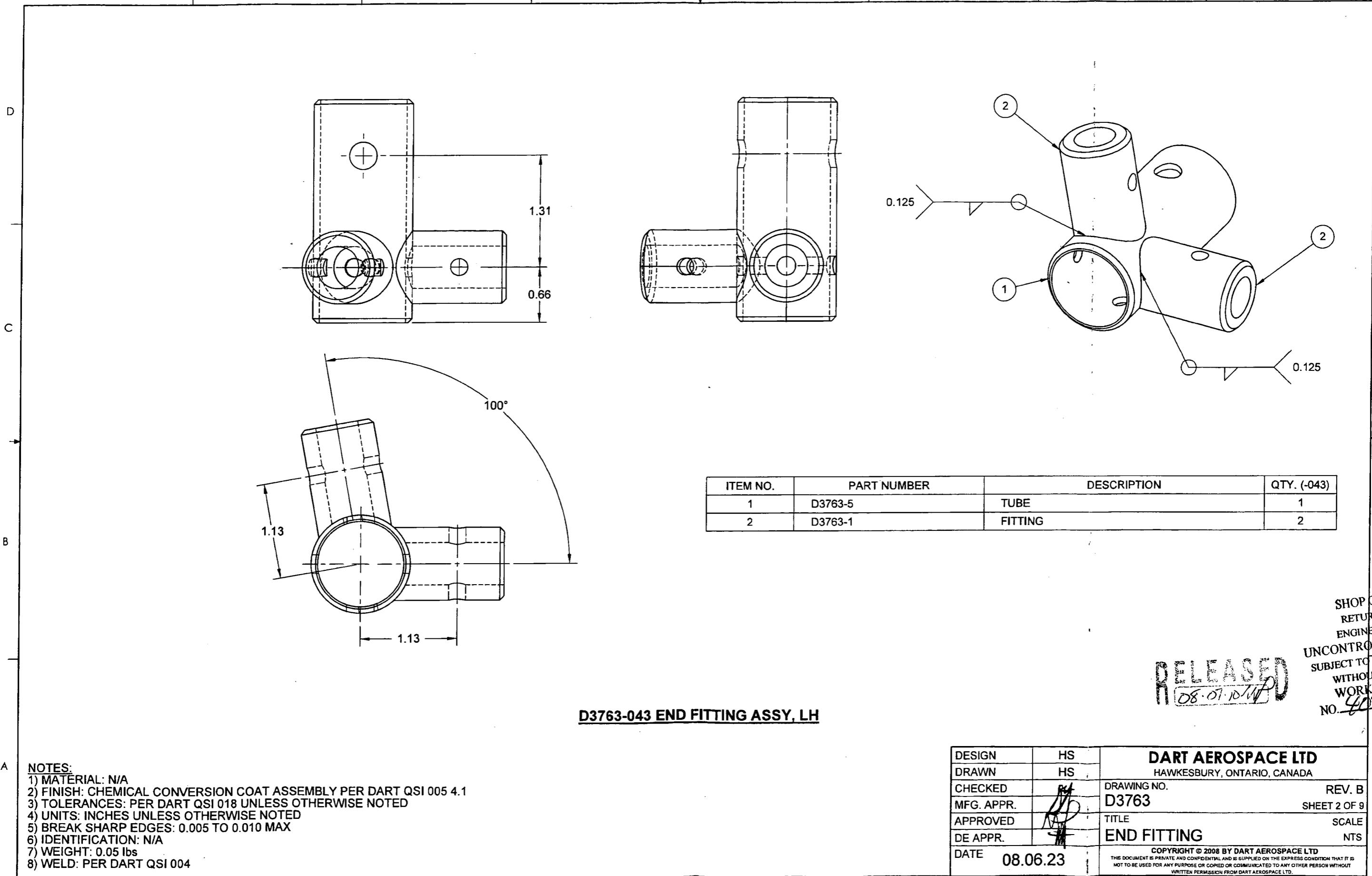
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|------|------|------------------|----|------|-----|-------------------------------------|--------------------------|
|      |      |                  |    |      |     |                                     |                          |
|      |      |                  |    |      |     |                                     |                          |

Part No: D3763-043 PAR #: N/A Fault Category: Prod. Eng. Co-act. NCR: Yes No DQA:  Date: 08/08/15  
QA: N/C Closed:  Date: 08/08/15

| WORK ORDER NON-CONFORMANCE (NCR) |      |  |                             |                                 |                |                           |                       |                          |
|----------------------------------|------|--|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE                             | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|                                  |      |  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
| 08/08/14                         | 6-0  | No chemical conversion<br>curr step on Estimate.<br>- WO were verified | Initial 2                   | Add Alodine to I.P.P.<br>- QC 3 |                | Initial 2                 | 08/08/14              | 08/08/14                 |
|                                  |      |  |                             |                                 |                |                           |                       |                          |
|                                  |      |  |                             |                                 |                |                           |                       |                          |

NOTE: Date &amp; initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

D

C

B

A